



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G11751-3G
Job Sheet 173122



Part No: RBW6205G11751-3G

Job Qty: 2 ea

Part Name: Guide



APR 05 2018

DAS
13

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G11751-3G REV 2 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		3/8/18	0.00	0.00	Start Up Waterjet2		
92	Purchasing	2 pcs		3/8/18	0.00	0.00	Purchasing		At 18/04/05
94	Packaging	2 pcs		3/8/18	0.00	0.00	Packaging2		At 18/04/05
96	QC	2 pcs		3/8/18	0.00	0.00	QC6		
100	Waterjet	2 pcs		3/9/18	0.25	0.33	Waterjet 2 OMAX		
110	QC	2 pcs		3/9/18	0.00	0.00	QC2 Waterjet-4		
120	CNC Vertical Machining	2 pcs		3/9/18	0.00	0.00	HAAS 1		N/A
130	QC	2 pcs		3/9/18	0.00	0.00	QC2 Machining-5		
140	QC	2 pcs		3/9/18	0.00	0.00	QC8 Machining-5		
170	Outsource	2 pcs		3/9/18	0.00	0.00	Outsource4		
180	Packaging	2 pcs		3/9/18	0.00	0.00	Packaging2		DAS 38 9-88
190	QC	2 pcs		3/9/18	0.00	0.00	QC6		
200	Packaging	2 pcs		3/9/18	0.00	0.00	Packaging3-2		
210	QC21-SA	2 Ea		3/9/18	0.00	0.00	QC21		GA CB

Part Op 92 - 1- Issue P/O to Arrow Tech Machine Works P/O# 039745 2- Manufacture RBW6205G11751-3G as per Descriptions: DWG 3- Certificate of conformity is required 039248

100 - 1-Cut as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary

120 - 1-Machine as per folio FB _____ FOLIO REV: _____ DWG REV: _____ 2- Run on Mazak 3-Deburr

130 - 1- Engrave T/N as per DWG

170 - -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required

180 - Receive

200 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G11751-3GP	Guide	2 (1 ea)	90-Start up Operation	5058293

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6205G11751-3GP	2	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description		Mfg Date: 04/05/18 Job No: 173122 Packaging Operation: Revision: Serial No/Batch: S058370 PART NO: RBW6205G11751-3G Change No: Guide			
		Completed By		Lead hand / Supervisor Approval Verification	
		QC / QA Coordinator Approval			

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
		OTHER : _____	

Inspection incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Part Specifications

Specifications could not be found.

Plex 2/26/18 11:48 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

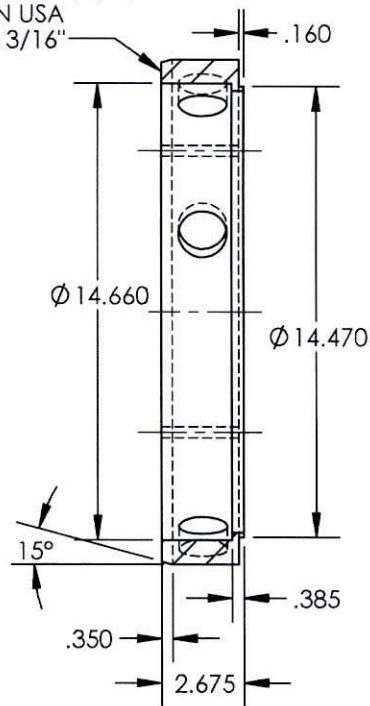
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

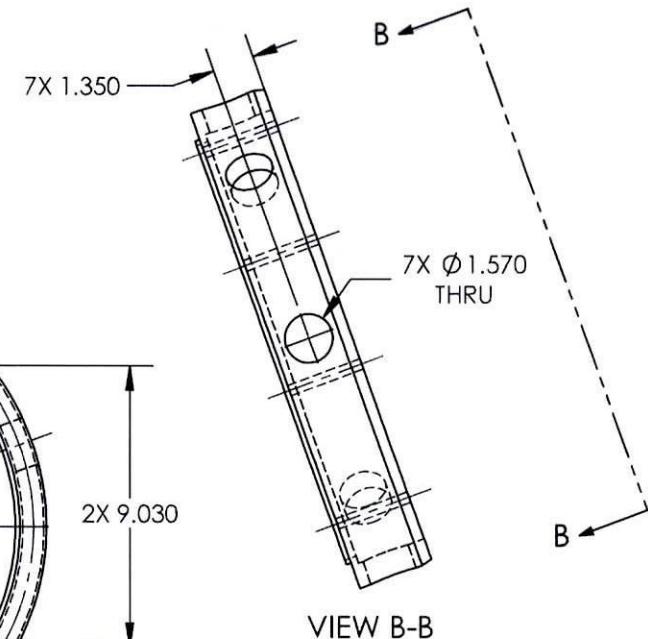
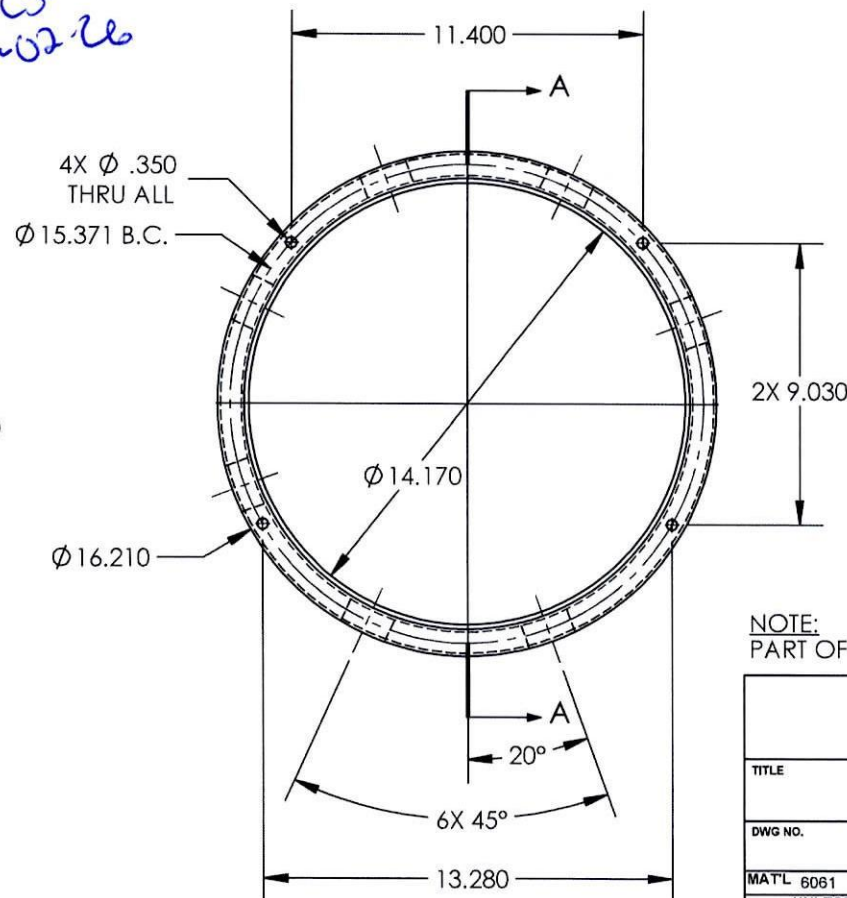
REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		CH'D O.D. CHAMFER FROM 13° TO 15°, CH'D MATERIAL FROM 2-3/4 TO 3 IN BOM.	1/31/2011	RJC
2	15-0144	CORRECTED SECTION A-A, ADDED AUXILIARY VIEW B-B.	6/15/2015	RJC

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173122 MJS
18-02-26

ENGRAVE T/N, S/N,
MADE IN USA
TEXT HT. 3/16"



SECTION A-A



NOTE:
PART OF KIT: RBW6205G11231-3G.

		TITLE	
		GUIDE	
DWG NO.	RBW6205G11751-3G		REV 2
MAT'L 6061	DRAWN BY: CLOUGH		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005 FRACTIONS ± 1/8		HEAT TREAT	
.XX ± .01 ANGLES ± 5°		FINISH CLEAR ANODIZE	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		SPEC MIL-A-8625F, TYPE II, CLASS I	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
		AGUSTA	
SCALE 1:6	DATE 4/30/2010	SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	GUIDE	6061		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039248**

Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: PO039248

PO Date: 3/8/18

Due Date: 4/19/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

REVISED

APR 05 2018

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	RBW6205G11651-3GP			Guide As Per Dwg RBW6205G11651-3G 1B	Partial	4/19/18	6 Ea	6 Ea	0 Ea	\$740.00/Ea	\$0.00
Line Item Note job# 173121											
					Firmed	4/20/18	2 Ea	0 Ea	2 Ea	\$740.00/Ea	\$1,480.00
Sub Total:							8	6	2		\$1,480.00
2	RBW6205G11751-3GP			Guide As Per Dwg RBW6205G11751-3G Rev 2	Partial	4/19/18	6 Ea	6 Ea	0 Ea	\$695.00/Ea	\$0.00
Line Item Note job# 173122											
					Firmed	4/20/18	2 Ea	0 Ea	2 Ea	\$695.00/Ea	\$1,390.00
Sub Total:							8	6	2		\$1,390.00
Grand Total:											\$2,870.00

Order Notes

4/5/2018

PURCHASE ORDER

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

CG

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/5/18 9:00 AM dart.lavoie.chantal



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART Aerospace

DATE: April 2, 2018

P.O.# 039248

WEJAY JOB# 39037

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
RBW6205G11651-3G-1B '19.6" Guide'	6	Machined complete per drawing req'ts.	RBW6205G11651-3G / rev.1B
RBW6205G11651-3G-2 '16.21" Guide'	6	Machined complete per drawing req'ts.	RBW6205G11651-3G / rev.2

Note: Material Test Certs attached - ref. 'KUMZ' Lot# 648135 (Wejay TN# 33965-1).

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith

Authorized Q.A. Signatory



INSPECTION CERTIFICATE № 17.127140

EN 10204 - 3.1

Consigner: KAMENSK URALSKY METALLURGICAL WORKS 5, Zavodskaya Str., Kamenak Uralsky, Sverdlovsk Region, 523405, Russia Tel: +7 (3439) 39 54 17 Fax: +7 (3439) 39 52 49					JOINT STOCK COMPANY						
Buyer: Thyssen Krupp Materials, NA					Quantity, pcs: 2						
Consignee: THYSSEN KRUPP MATERIALS, NA					Net Weight, kg: 2165						
P.O. No: PEC-282822					S.O. No: N17078						
Article No: -					Item No: 1.5						
					Package No: 612318						
Description of Goods: Plates					Requirements on the Products:						
Grade of Product					Material conforms to quality of alloy: B061 T651						
Dimensions, inch (mm)					Product conforms to all requirements of:						
2.75"X80.5"X144.5" 69.850X1536.7X3670.3					ASTM B209-14; SAE AMS 4027 Rev. N (2014); SAE AMS-QQ-A-250/11A (2008). This product conforms to European Union RoHS Directive 2011/65/EU						
Mechanical Properties											
The Condition of Tested Standards	Lot No.	Heat lot No.	HT Charge No.	Sampling direction	Tensile Strength, Rm / Cut ksi		Yield Strength, Rp0.2% / Clenching test ksi		Elongation, %		Hardness, HBW
					min	max	min	max	min	max	
Required				LT	42.0	-	35.0	-	6	-	-
	646135	12-6271	07181	LT	47.2	47.8	43.4	43.9	10.9	10.9	-
Chemical Composition, %											
Element	Silicon Si	Iron Fe	Copper Cu	Manganese Mn	Magnesium Mg	Chromium Cr	Zinc Zn	Titanium Ti			
Required	0.40 - 0.8	0.7	0.15 - 0.40	0.15	0.8 - 1.2	0.04 - 0.35	0.25	0.15	-	-	-
Contents	0.64	0.36	0.17	0.09	1.0	0.08	0.14	0.08	-	-	-
Element									Other Elements		Aluminum Al
									Each	Total	
Required	-	-	-	-	-	-	-	-	0.05	0.15	remainder
Contents	-	-	-	-	-	-	-	-	0.05	0.15	remainder
Other Tests											
Method	Macro-structure	Micro-structure	UT	K1c	Electro-conductivity, IACS%	SCF	Contents H2 of metals	Raw material used for manufacturing supplied products was tested for compliance with international radiation safety regulations during incoming inspection. Russia is country of melt and manufacture.			
							STR 104 014-2011 MAX 0.25				
Result	-	-	-	-	-	-	0.16				

On behalf:

Date:

QCB Inspector

Inspection Department Engineer



KUMZ J.S.Co.

26.07.2017

Gureva V.N.

Zyryanova K.V.

TN33965-1

Job #39037

REF. DART AEROSPACE P.O.#039248

